

Work Order ID 77850-2

December-22-11 8:19:49 AM

77850

Page 1

Item ID: D4093-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 22/12/2011 Start Qty: 16.00

16

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/12/22 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4093

C

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV: C

PROG REV: C

DEBURR

0.00

181-12-08

12

78 12-02-14

16

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

181-12-08

Work Order ID 77850

December-22-11 8:19:49 AM

77850

Page 2

Item ID: D4093-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 22/12/2011 Start Qty: 16.00

16

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

8/26/14

Quality Control

132

0.00

132

Small Fab

Memo

0.00

AT 11/12/28

Small Fab

DRILL AS PER DWG

135

QC5- Inspect part completeness to step on W/O

0.00

135

QC

Memo

0.00

8/26/14

(412)

Quality Control

Work Order ID 77850

December-22-11 8:19:49 AM

77850

Page 3

Item ID: D4093-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 22/12/2011 Start Qty: 16.00

16

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

12 BL 12-2-14.

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12 x 4 m-l 12/02/14

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

EP 12/02/15 (12)

Work Order ID 77850

December-22-11 8:19:49 AM

77850

Page 4

Item ID: D4093-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 22/12/2011 Start Qty: 16.00

16

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

[Signature] M.C.J. 12/02/15

[Signature] 12-02-15
[Signature]

Picklist Print

December-22-11 8:19:55 AM

Page 1

Work Order ID: 77850

77850

Parent Item: D4093-3

D4093-3

Parent Item Name: Bracket

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP REV:A NEW ISSUE 10-10-04 JLM VERIFIED BY:DD IPP
 REV:B AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD IPP
 REV:B AS PER REV C 11-09-28 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X06.00 0		Purchased		No			f	42.6600		16			

M6061T6B0 750X06 000

6061T6 BAR .750 X 6.00

**

11-12-28

Location

MAT003

Loc Qty

42.66

18.66





24



Loc Code

119231

16

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: 		Audited by: 		Preliminary Approval: 	
Date: 11-10-13		Date: 12/02/14		Date: 	


Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue	KJ 	

Work Order: 77850

Part Number: 4093-3

Page 1 of 1

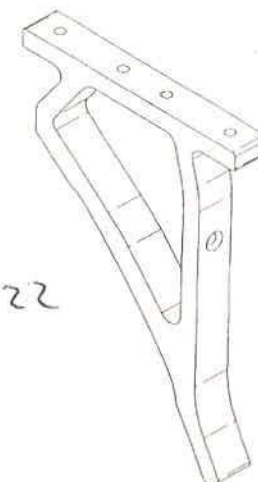
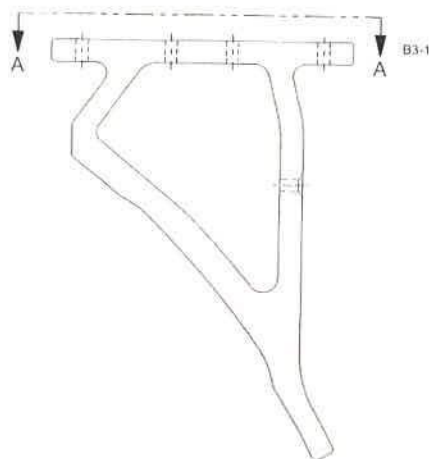
X	First Article	X	Prototype
---	---------------	---	-----------

Measured by:	
Date:	12/01/02

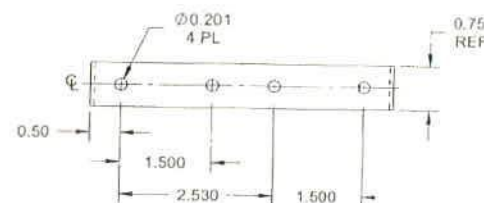
Audited by: S
Date: 6/02/14

Prototype Approval: _____
Date: _____

ISO 9001:2000 Quality Assurance and Improved Quality Control



77850 M.L.J
11/12/22



SECTION VIEW A-A D6-1

D4093-1 BRACKET

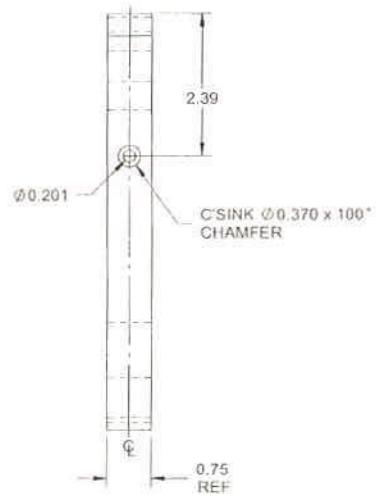
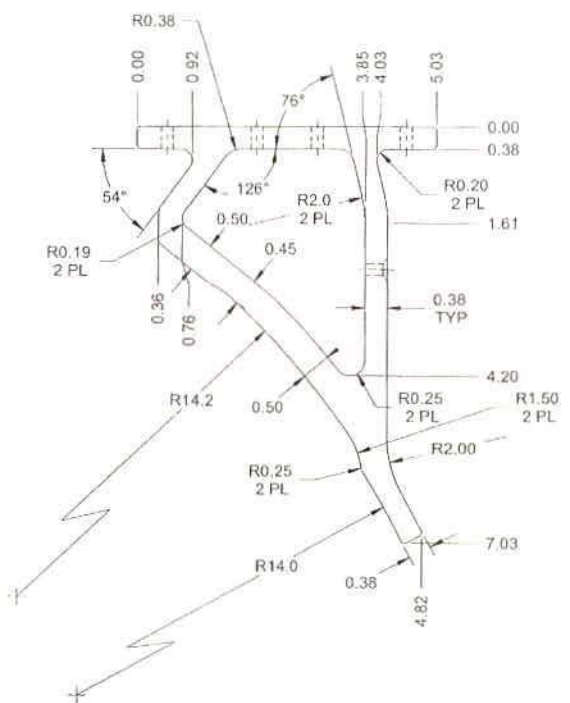
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4126/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.54 lbs

RELEASED
2011-09-22

C	REDRAWN D4093-11-3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-11-3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4093	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED FOR ANY PURPOSE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

77850

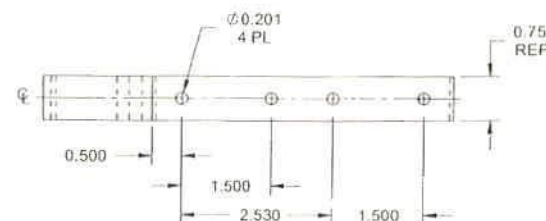
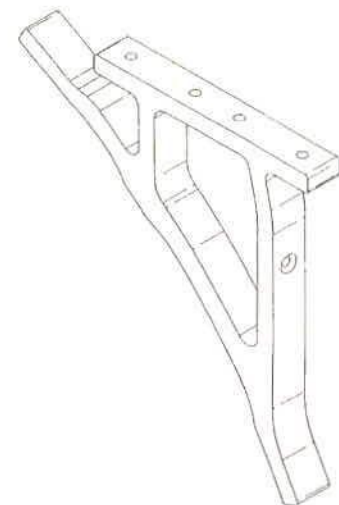
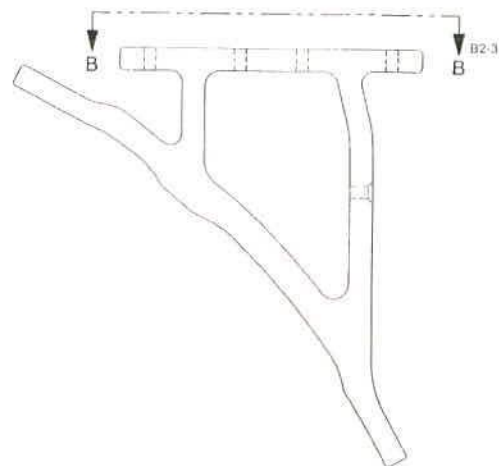


D4093-1 BRACKET

RELEASED
2011-09-22
JMD

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RF</i>	D4093	SHEET 2 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE USED FOR ANY PURPOSES OR LOCATIONS OR FOR ANY OTHER REASONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

77850



D4093-3 BRACKET

SECTION VIEW B-B B5-3

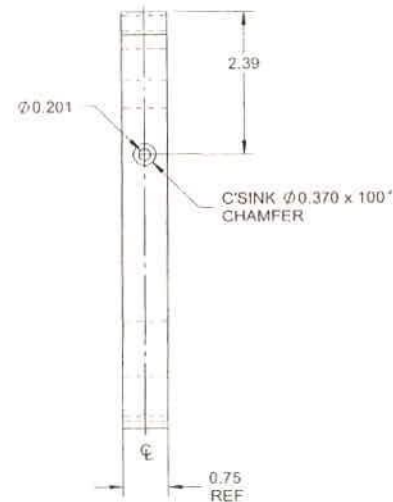
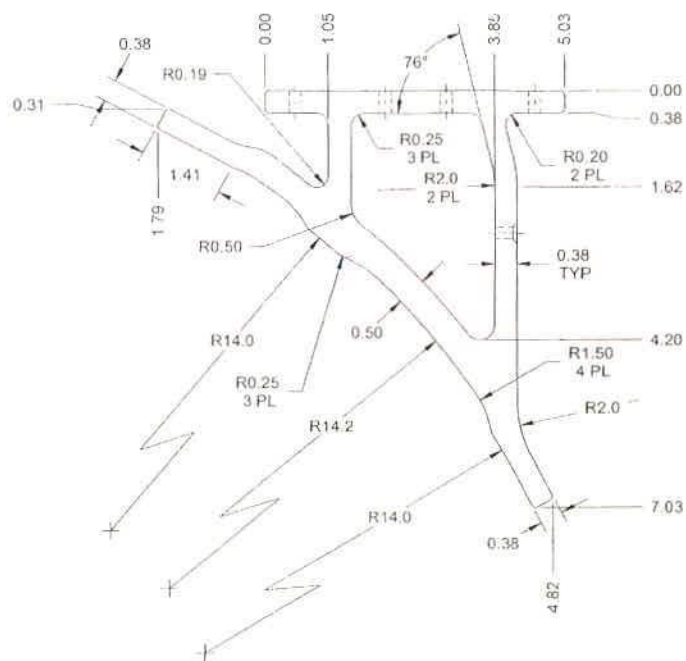
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4093	REV. C
MFG. APPR.	<i>RF</i>		SHEET 3 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OUTSIDE OF THE CONTRACT TO WHICH IT IS REFERENCED. http://www.dart-aerospace.com</small>	

77850

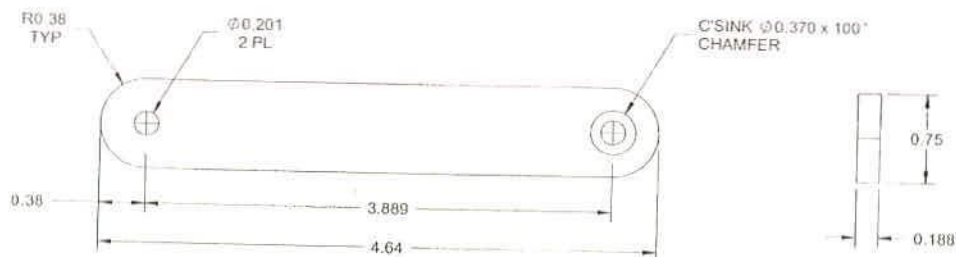


D4093-3 BRACKET

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>RF</i>	D4093	SHEET 4 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BRACKET	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED, REPRODUCED, COPIED, OR OTHERWISE USED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

77850



D4093-5 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	140	DRAWING NO.	REV. C
MFG. APPR.	21	D4093	SHEET 5 OF 5
APPROVED	140	TITLE	SCALE
DE APPR.	140	BRACKET	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE BASIS OF A DART AEROSPACE USA, INC. PATENT. NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	